

Work Order ID 85126

85126

Page 1

June-04-12 8:21:05 AM

Item ID: D350-591-214

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Short RH

Start Date: 04/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/04 Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3078

A

DSI 9472

A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

Handwritten: MLJ 12-7-17 (S)

Handwritten: 5 φ A2

Handwritten: 12.06.26

Handwritten: 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop *NS2*

Start Date: 04/06/2012 **Start Qty:** 5.00

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5

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Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____

Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

120

QC

Memo

0.00

Quality Control

0.00

130

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg

D3078

A/R Aluminum Rod 120854

3-Grind End Plate flush

QC9- Inspect visual per QSI004- Fusion Welds

0.00

140

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Required Date: 18/06/2012 **Req'd Qty:** 5.00 ***5***

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____

Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

QC5- Inspect part completeness to step on W/O

0.00

150

0.00 Silicate

QC

Memo

0.00

Quality Control

Chemical Conversion Coat per QSI005 4.1

0.00

160

Memo

0.00

HandFinish

Hand Finishing

QC3- Inspect Part Finish

0.00

170

Memo

0.00

QC

Quality Control

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: QC: Date: SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Large Fab

Large Fab

Memo

0.00

Large Fab

1- Rivet Leg Assembly as per Dwg D3078.

2-Bevel Aft end for welding

3-Inspect for foreign object as per QSI 024

4-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod 120854

120130

5-Grind End Plate flush

5

0

Ae 12.07.12
JL 12.07.12
Ae 12.07.13

210

QC10- Inspect visual per QSI004- ground welds

0.00

210

QC

Memo

0.00

Quality Control

DAS 16 2-8 2/2/10

1

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Stop ***NR2***

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220 QC5- Inspect part completeness to step on W/O

0.00

DAS 16

0.00

220

QC

Memo

Quality Control

230 Chemical Conversion Coat per QSI005 4.1

0.00

230

HandFinish

Memo

Hand Finishing

240 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

240

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*12:10
3200 F
12:40*

*5X
RH*

*5X
RH*

*M-L
12/07/16*

*M-L
12/07/16*

m121841

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Required Date: 18/06/2012 Req'd Qty: 5.00 ***5***

Customer:

Reference:

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QC: _____ Date: _____ SPC (Y/N): _____

Date:

Run Start ***NR1***

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
--------------------------------	--------------------------	----------------------

250	Wing Walk as per dwg QSI005 4.4 Batch <u>121505</u>	0.00
-----	---	------

250

HandFinish

Memo

0.00

Hand Finishing

260	QC3- Inspect Part Finish	0.00
-----	--------------------------	------

260

QC

Memo

0.00

Quality Control

270	Pick Kit	0.00
-----	----------	------

270

Packaging

Memo

0.00

Packaging

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

5	0					<u>12/07/16</u>
---	---	--	--	--	--	-----------------

5.34 4 12/07/16

5 12/07/17

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Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC4- 100% Inspect kits for completeness

0.00

280

QC

Memo

0.00

Quality Control

290

Packaging

0.00

290

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-214

Location: 6

PPP Rev: _____

300

QC21- Final Inspection - Work Order Release

0.00

300

QC

Memo

0.00

Quality Control

DAS
16

12/07/17

TS
RH

SX

12/17/12

12/7/18

MF
12-07-18

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 85126

85126

Parent Item: D350-591-214

D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:B05.10.14Modified step 10KJ/EC

IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM

IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

IPP Rev:D

10.11.15 update qty on AN4-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			110	Each	156 6100	0.5	2.5			
D2622-120C									**			As 12.06.26	
Step Extrusion													

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	130.88	
81507	4.88	
83894	126	2.5
WA013	9.36	
75781	2	
77612	7.36	

D3063-1

Manufactured No

130

Each

53.0000

1

5

D3063-1

Support

**

Location	Loc Qty	Loc Code
WA016	53	
71886	53	5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 85126

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

85126

D350-591-214

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3067-1

Manufactured No

130

Each

172.0000

1

5

D3067-1

End Plate

**

12.07.03

Location

Loc Qty

Loc Code

WA

139

78608

4

83855

60

84534

75

WA016

33

67582

2

68214

1

79607

1

83053

29

D3066-1

Manufactured No

200

Each

71.0000

2

10

D3066-1

Spacer

**

12.07.12

Location

Loc Qty

Loc Code

ST176

71

83854

71

MS20600-AD4W4

Purchased No

200

Each

3,464.000

16

80

MS20600-AD4W4

Rivets

**

12.07.12

Location

Loc Qty

Loc Code

321

1000

121652

1000

ST321

2324

121011

9

121340

315

121444

2000

WA018

140

118840

140

June-04-12 8:21:11 AM

Shop Packet Print

Page 2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Heli-Access-Step. Short RH

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D350-591-214

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3065-041

Manufactured No

200

Each

13.0000

1

5

D3065-041

Step Leg Assembly Hi

**

B83871 (x5) Ae
12.07.12

Location

Loc Qty

Loc Code

WA

13

66149

0

79336

1

80880

12

D3067-1

Manufactured No

200

Each

172.0000

1

5

D3067-1

End Plate

**

12.07.13

Location

Loc Qty

Loc Code

WA

139

78608

4

83855

60

84534

75

WA016

33

67582

2

68214

1

79607

1

83053

29

AN4-16A

Purchased No

270

Each

169.0000

20

✓

AN4-16A

Bolt

**

122416 JB - 12/07/17

Location

Loc Qty

Loc Code

ST358

169

120498

14

121060

30

121444

75

121541

50

June-04-12 8:21:11 AM

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D350-591-214

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

D2732

Manufactured No

270 f

520.9153 1 5 ✓

D2732

Rubber Extrusion

**

JB

Location

Loc Qty

Loc Code

ST410

520.915299

70987

20.915299

83560

500

83560

Purchased No

270 Each

116 0000 10 ✓

AN3-35A

AN3-35A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST353

116

121652

116

121652

Purchased No

270 Each

296.0000 10 ✓

AN4-11A

AN4-11A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST356

296

118706

46

120731

100

121243

50

121708

100

121708

AN960JD416

NAS1149D0463J

Purchased No

270 Each

30.0000 60 ✓

AN960JD416

Washer

**

121912 JB 12/07/17

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

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Parent Item Name: Heli-Access-Step. Short RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

D2230-3

Manufactured No

270

Each

90.0000

2

10 ✓

D2230-3

Lug

**

84133 JB



Location

Loc Qty

Loc Code

ST480

90

83261

90

D2856-400

Manufactured No

270

f

230.5445

0.6

3 ✓

D2856-400

Abrasion Strip

**

JB



Location

Loc Qty

Loc Code

ST403

216

81875

216

ST409

14.5445

63735

0.6696

68076

0.3149

71164

8.46

79551

5.1

81875

cut 7 20" long, qty 1

MS21042L3

Purchased

No

270

Each

2,195.000

2

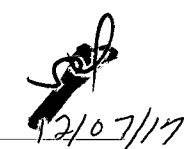
10 ✓

MS21042L3

Nut

**

JB



Location

Loc Qty

Loc Code

ST300

2195

117885

32

119017

952

119075

138

121349

221

121444

852

121444

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D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN4-13A

Purchased

No

270

Each

1.261.000

4 20

AN4-13A

Bolt

**

JB



Location

Loc Qty

Loc Code

ST357

1261

119449

33

120187

19

120422

2

120770

207

121652

1000

D2230-1

Manufactured

No

270

Each

20 0000

D2230-1

Lug

**

2 10

2x84135

8x84136

JB



Location

Loc Qty

Loc Code

ST480

20

83273

20

MS21042L4

Purchased

No

270

Each

3.910.000

6 30

MS21042L4

Nut

**

6

JB



Location

Loc Qty

Loc Code

ST300

3910

119075

116

121011

537

121444

2957

121652

300

AN960JD10

NAS1149D0363J

Purchased

No

270

Each

0.0000

4 20

AN960JD10

Washer

**

4

JB



12/07/17

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step ™, Short Step – High Skid, LH
	X			D350-591-214	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

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SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER
NO. 85126NCS
12/09/04

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	NCS	DSI 9472	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BOLT ADDITION	NTS
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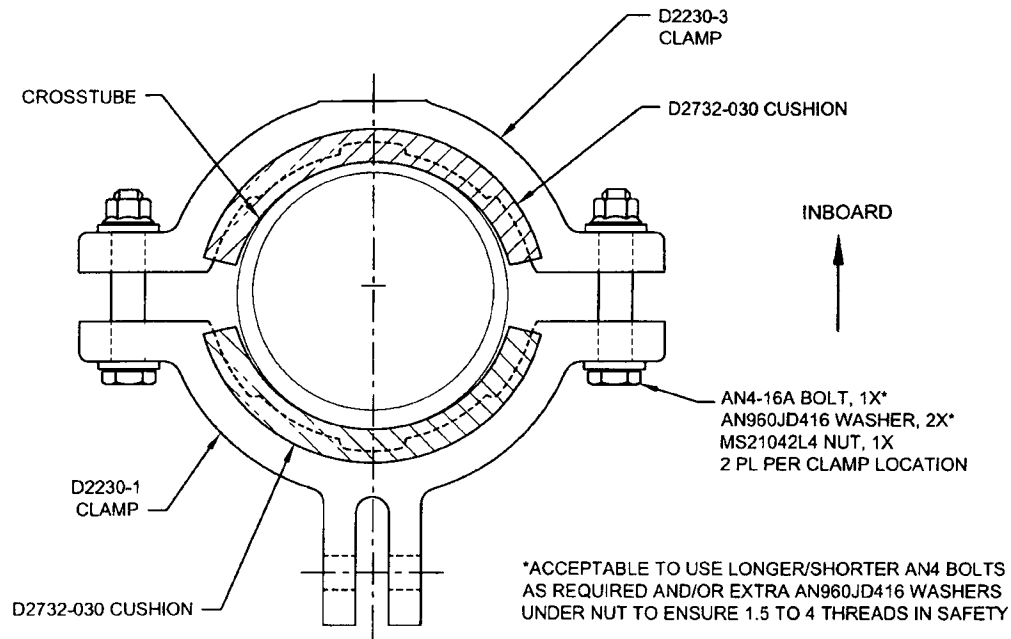


FIGURE 1: CLAMP DETAIL
OPTIONAL CLAMP CONFIGURATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	<i>97</i>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>97</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOLT ADDITION	NTS
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95126



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.11

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

02150

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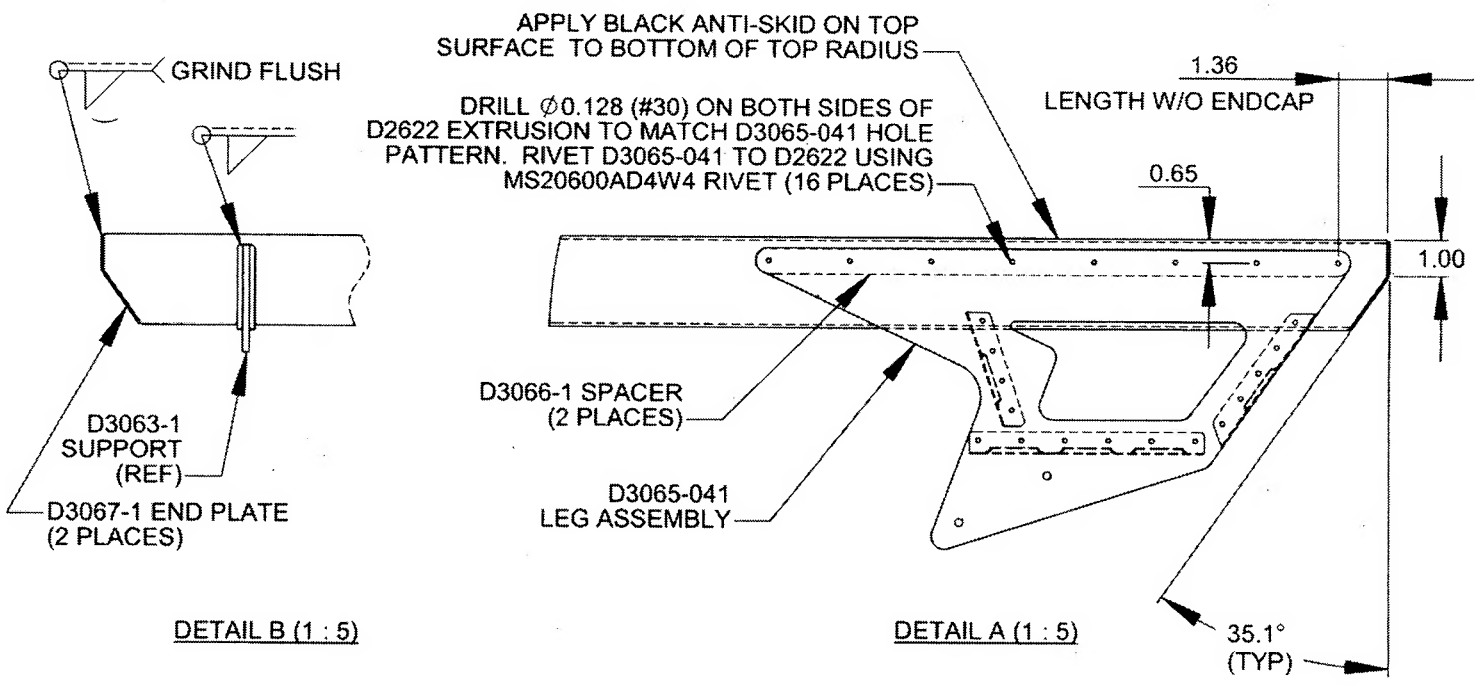
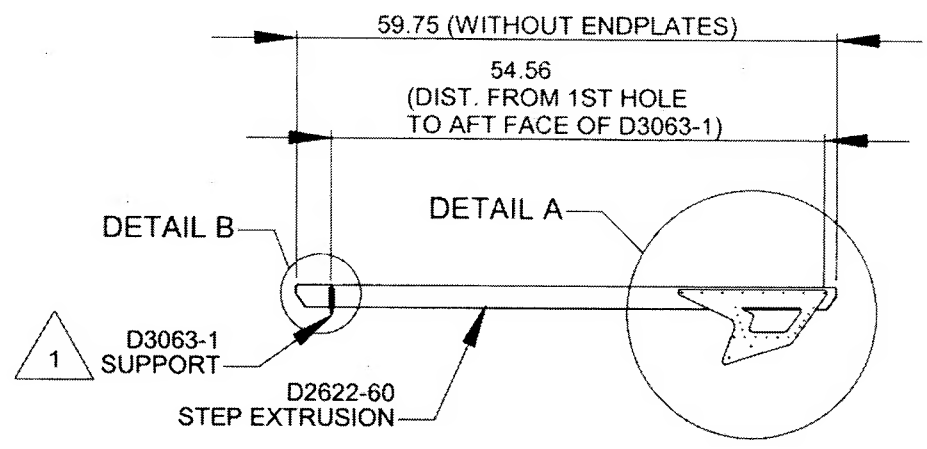
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RELEASED
02.09.2004

DART



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	CP	DRAWING NO. D3078
DATE	02.09.11	TITLE	STEP ASSEMBLY, HI SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	



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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

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AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
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	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
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


APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05

CERT. NO.: SH92-6

ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
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